



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D117-1044-011
Job Sheet 170718



1-1
002665

Part No: D117-1044-011

Job Qty: 1 ea

Part Name: Heli-Utility-Basket™, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/18/18

Job Tracking No:

Due Date: 3/30/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: IIN-D117-1044 REV.B IPP REV:A 18.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/30/18	0.00	0.00	Start Up Stores/Pkg-1		APR 20 2018
110	Packaging	1 pcs		3/30/18	0.00	0.00	Packaging1-1		APR 27 2018
130	QC	1 pcs		3/30/18	0.00	0.00	QC4		DAS 58
135	DC	1 pcs		3/30/18	0.00	0.00	DC		9-89 DAS 58
140	Packaging	1 pcs		3/30/18	0.00	0.00	Packaging3-1		APR 27 2018
150	QC21-FG	1 Ea		3/30/18	0.00	0.00	QC21		APR 27 2018

Part Op 135 - Photocopy bluefile & type labels per PPP D117-1044-011 CHG 001

Descriptions: 140 - Identify and pack for shipping as per PPP D117-1044-011 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D117-1044-113 ✓	QR Basket Provision Mounting Installation, LH	1 Ea (1 ea)	90-Start up Operation	5064692
D5067-011 ✓	Basket Assembly, Heavy Duty Lid, LH	1 Ea (1 ea)	90-Start up Operation	5051415
D5203-043 ✓	Strut Assembly	1 Ea (1 ea)	90-Start up Operation	5060029

Part Specifications

Specifications could not be found.

Plex 1/18/18 3:16 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																													
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Description V Dart Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartero.com www.dartaerospace.com Container No: S064698 Part: D117-1044-011 Job No: 170718 Serial No/Batch: S064698 Revision: B Inspector: Date: 04/24/18																																																																																	
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> </table>		Environment ☐	No Re-verification ☐			Design ☐	Operator ☐			Doc/Data ☐	Offset/Setup ☐			Equip/Tooling ☐	Supplier ☐			Handling/Pre ☐	Training ☐			Material ☐	Use for Testing ☐			Internal Transport ☐	Poor Information ☐			Tribal Knowledge ☐	Rushing ☐			LOA ☐	Product Improvement ☐			Substation ☐	Process Improvement ☐			Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐			<table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Inspection Incomplete/Unqualified</td> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Contamination</td> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Countersink</td> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Cut Too Short</td> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Instructions Incomplete/Unclear</td> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Drill Holes</td> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>		☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Positioned Wrong	☐ Contamination	☐ Out of Sequence	☐ Outside Dimensions	☐ Countersink	☐ Off-set	☐ Over/Under tolerance	☐ Cut Too Short	☐ Mislabeled	☐ Part Incorrect	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Part Lost/Missing	☐ Drill Holes	☐ Misaligned/off center	☐ Part Moved			☐ Drawing			☐ Finish			☐ Misread			☐ Turning Sequence
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4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the Heli-Utility-Basket™ kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1044-011/-012 (Heli-Utility-Basket™, LH/RH Install)	134 lb 60.8 kg	+/-40.5 in +/-1.03 m	+/-5427 in-lb +/-62.6 m-k-g	167 in 4.24 m	22378 in-lb 257.8 m-k-g
D117-1044-111 (Crosstube Adapter Kit, Install)	3.5 lb 1.6 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-k-g	165.5 in 4.20 m	579 in-lb 6.7 m-k-g
D117-1044-113/-114 (QR Basket Mounting Provision Kit, LH/RH Install, includes D117-1044-111 Crosstube Adapter kit above)	56 lb 25.4 kg	+/-14.7 in +/-37 m	+/-823 in-lb +/-9.4 m-k-g	167 in 4.24 m	9352 in-lb 107.7 m-k-g

5.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -111	Qty -113	Qty -114	Part Number	Description
X						D117-1044-011	HELL-UTILITY-BASKET, LH
	X					D117-1044-012	HELL-UTILITY-BASKET, RH
		X				D117-1044-013	PROP ARM KIT (OPTIONAL)
			X	1	1	D117-1044-111	CROSSTUBE ADAPTER KIT
1				X		D117-1044-113	QR BASKET MOUNTING PROVISION KIT, LH
	1				X	D117-1044-114	QR BASKET MOUNTING PROVISION KIT, RH
		1*				D2332-041	PROP ASSEMBLY (OPTIONAL)
1						D5067-011	BASKET ASSEMBLY, HEAVY DUTY, LH
	1					D5067-012	BASKET ASSEMBLY, HEAVY DUTY, RH
			4			D5069-1	HARDPOINT ADAPTER
1	1					D5203-043	STRUT ASSEMBLY
				1		D5549-011	FWD BEAM ASSEMBLY, LH
					1	D5549-012	FWD BEAM ASSEMBLY, RH
				1		D5549-013	AFT BEAM ASSEMBLY, LH
					1	D5549-014	AFT BEAM ASSEMBLY, RH
			1			D5612-041	ADAPTER WRENCH
			4			DIN65270-12D	NUT
			4			EN2367-23025	PIN, COTTER
		2*				MS24665-300	COTTER PIN

* D2332-041 PROP ASSEMBLY & HARDWARE (OPTIONAL) TO REPLACE D3969-3 GAS SPRING

PAGE 1 OF 1

Description: HELI-UTILITY BASKET, LH

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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